

# Work Order ID 68406

Tuesday, April 12, 2011 3:38:28 PM



## PRELIMINARY ISSUE

Page 1

Item ID: D4369-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bar

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00

Customer:



Reference:

Approvals:

Process Plan: *[Signature]*

Date: *11-04-12* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4369

PA1

100

0.00



Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 52.25"

*[Signature]* 11/04/27 *[Signature]*

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB045 & dwg D4369,

FOLIO REV: \_\_\_\_\_

DWG REV: \_\_\_\_\_

2-Deburr as required

*[Signature]* 11/04/28 *[Signature]*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68406**

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Page 2

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/04/28



130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/4/28

①

140

0.00



Small Fab

Memo

0.00

Small Fab

Grind off chamfer on fwd end of bar as per dwg

11/04/28



W/O:		WORK ORDER CHANGES						
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Page 3

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00 -inspects to PA-1



QC

Memo

0.00

Quality Control

Due only  
Saw 4/17/11 (41)

160

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

0.00

Packaging

11-5-3 (X1)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11.21.13 AUTH W

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

11-23-82

MF

11-05-03

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 12, 2011 3:38:35 PM

Page 1

Work Order ID: 68406



Parent Item: D4369-3



Parent Item Name: Bar

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	269.5000	4.354	4.583158			
304 BAR .250 x .500													

Location

Loc Qty

Loc Code

MAT006

78

116148

78

MAT050

191.5

117176

191.5

4.4

11/04/28

W/O:		WORK ORDER CHANGES						
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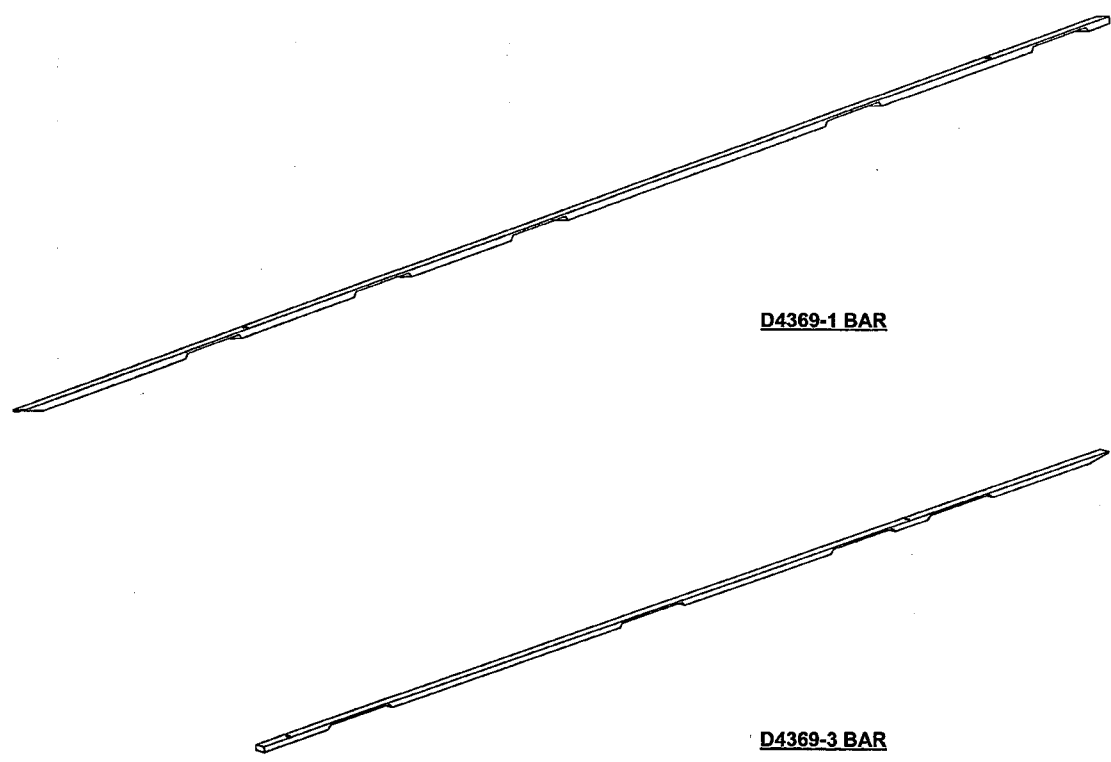
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1



**D4369-1 BAR**

**D4369-3 BAR**

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 684106

*PL 11-04-18*

**PRELIMINARY  
 ISSUE**

PA1	NEW ISSUE	SC	11.03.24
REV.	DESCRIPTION		BY DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D4369</b> REV. PA1 SHEET 1 OF 2 TITLE <b>BAR</b> SCALE NTS DATE <b>11.03.24</b>	
DRAWN	SC		
CHECKED	<i>[Signature]</i>		
MFG. APPR.			
APPROVED			
DE APPR.			

8 7 6 5 4 3 2 1

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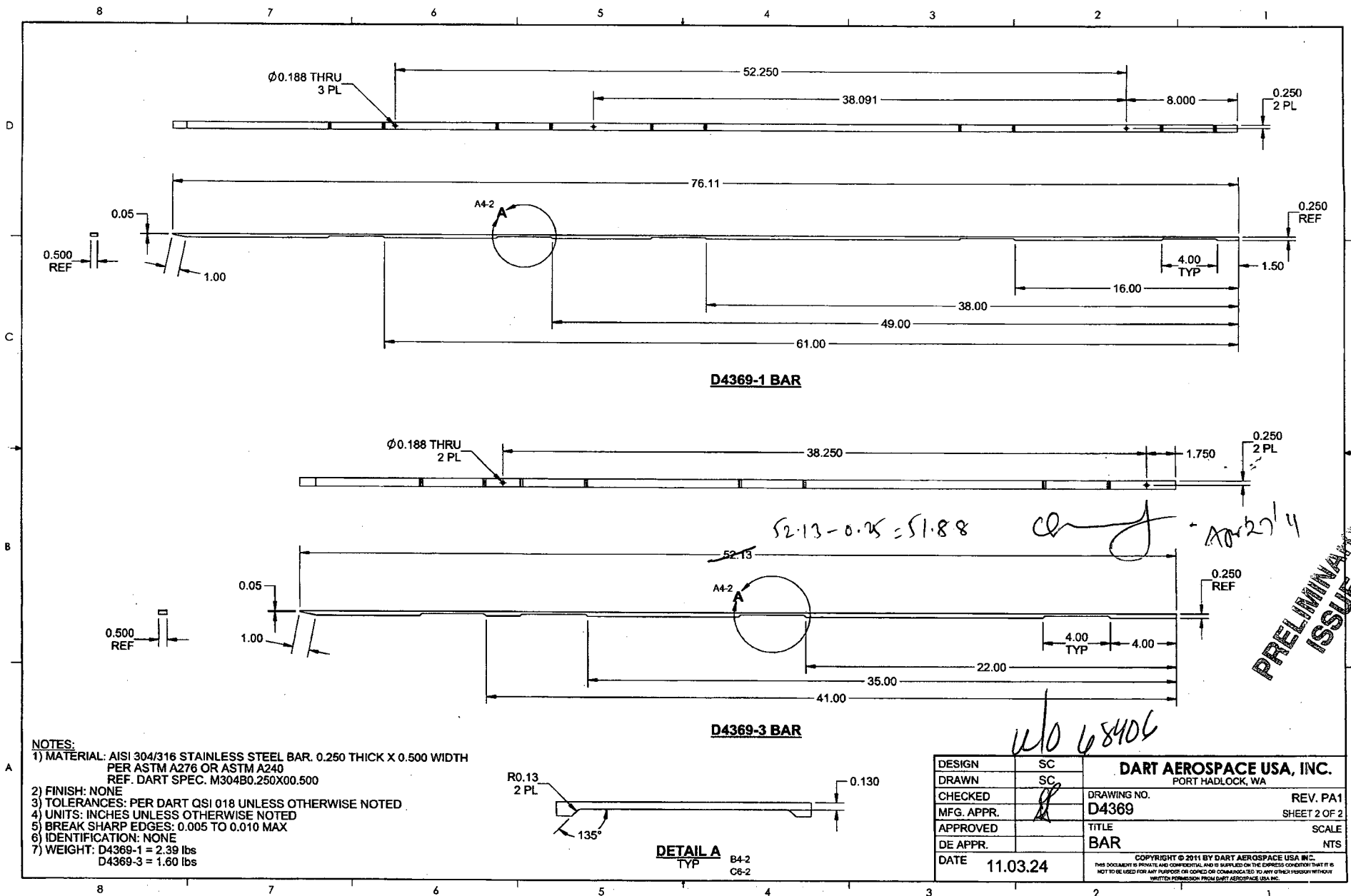
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